

Date: Tuesday, 4/17/2007 3:47:29 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 31897		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 4/17/2007	Drawing Number	: D3389 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 30790	Material	: N/A
Written By	: <u>Kim Johnston</u>	Due Date	: 4/30/2007
Checked & Approved By	: <u>Kim Johnston</u>	Qty:	6 Um: Each
Comment	: Est Rev:A 05-08-31 New issue KJ/JLM Est Rev:B 06-02-08 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B 25751

JD 7-4-19

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1  
1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

JD 7-4-19

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

DP

7-5-15

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4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

JD 7-5-16

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 07/05/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7-5-8	2	0.257 hole drilled on wrong end of web	<i>[Signature]</i> GS1042	enlarge 0.257 hole to 0.625	JD 7-5-15	DP 7-5-22	<i>[Signature]</i> 07.05.22	<i>[Signature]</i> 07.05.22

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 31897

Part Number: D33891.

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-5-16

(6)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP

7-5-16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6)  
207/05/22

Job Completion



207/05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

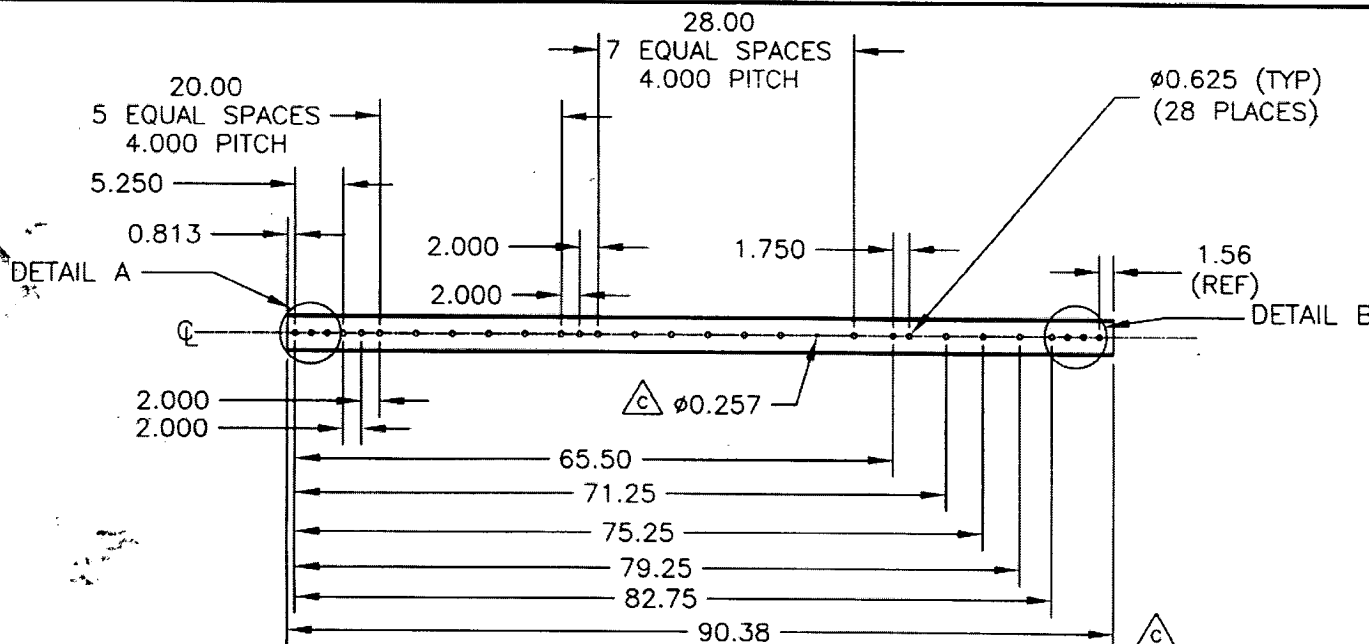
NOTE: Date & initial all entries

**DART**

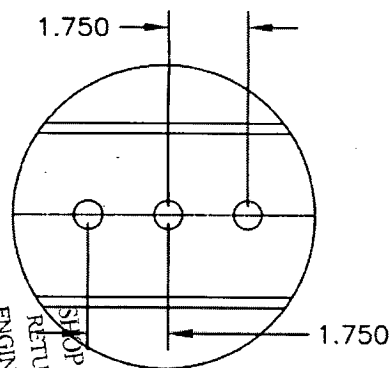
RELEASE

06.01.23

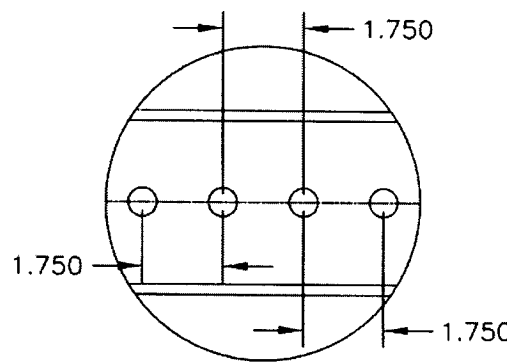
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	06.01.23	TITLE	412 WEB	REV. C
A	05.02.07	DRAWING NO.	D3389	SHEET 1 OF 1
B	05.06.13	NEW ISSUE	UPDATE DIMENSIONING	SCALE
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE		1:20



**D3389-1 DRILLING DETAIL**



**DETAIL A  
(SCALE 1:4)**



**DETAIL B  
(SCALE 1:4)**

**D3389-1 412 WEB**

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31897

